

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029369**Date Inspected:** 03-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Welder Rick Clayborn #2773:

Welder was observed performing Carbon Arc Gouging (CAG) and welding from face B on weld 12E PP116.5 E2. 0-DAH in way of indications rejected with Ultrasonic Testing (UTSW) by QC Inspector Bernard Docena. The indications were 1st time rejects on the SPCM A Deck plating weld with insufficient cumulative length and depth to warrant an "Engineer's Approval" and a Request for Weld Repair (RWR). The welder was observed welding utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1004 Repair for Shielded Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Bernard Docena and appeared to be in compliance with the WPS noted above.

Welder Eric Sparks #3040:

The welder was observed welding the 2" x 2" x 0.25 angles and the C3 x 4.1 Channels on the Bike Beam Path north side plate at 1 meter before and after of Panel Point 89 as per RFI-2995 R1 / CCO266. The welder was observed welding utilizing the Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Fred Michaels throughout the day and appeared to be in compliance with the WPS noted above. Welder Earl Clayborn was noted assisting welder Eric Sparks throughout the day.

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F.W. Spencer Welder Damian Llanos :

The welder was observed welding 3" diameter pipe butt welds for the Bike Beam Path water service line. The welds were identified as welds 1/CA2/115.5 /BE and 1/CA2/116.5 /BE. The welder was observed welding utilizing the Welding Procedure Specification (WPS) 1-12-1 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Fred Michaels. throughout the day and appeared to be in compliance with the WPS noted above.

F.W. Spencer Welder Rick Kickvee :

The welder was observed continue with welding 2.5" diameter pipe socket welds for the Bike Beam Path water service line. The weld was identified as weld 1/CA2/126.5 /BE. The welder was observed welding utilizing the Welding Procedure Specification (WPS) 1-12-1 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Fred Michaels. throughout the day and appeared to be in compliance with the WPS noted above.

Non-Destructive Testing (NDT)

This QA performed Visual Testing (VT) and Magnetic Particle Testing (MPT) on the following:

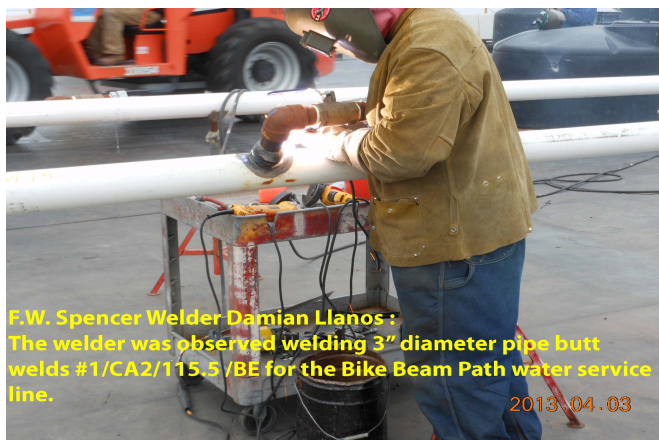
Bike Beam Path Side Plate:

- Temporary attachment removals at Panel Point 75.5, 78 & 79.
- Angle and Channel Attachment Welds at 1 meter on both side of PP89.

See TL-6028 for MPT report information.

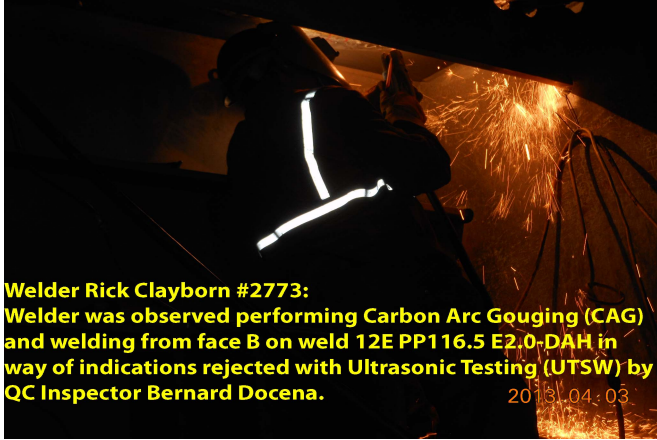
The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Conversations this day as required for scope of work.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
